

Work Order ID 151008

Monday, September 12, 2016 9:01:35 AM

151008

Page 1

Item ID: D3847-11

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearpad

Start Date: 9/14/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/19/2016 Req'd Qty: 4.00

4

Customer:

Reference:

DAS

SEP 13 2016

Approvals:

Process Plan:

21
9-89

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3847

D

PR 16/09/22

100

0.00

100

Waterjet

Memo

0.03

FLOW CNC Waterjet

1-Cut as per Dwg D3847

Dwg Rev: PProg Rev: D

2-Deburr if necessary

4

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.01

Quality Control

4

PR 16/09/23

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Monday, September 12, 2016 9:01:35 AM

Page 2

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification ☐	☐	Pressure/Forced ☐	☐	Temperature/Cure ☐	☐
Design ☐	☐	Operator ☐	☐	Bending ☐	☐	Set-up ☐	☐
Doc/Data ☐	☐	Offset/Setup ☐	☐	Centre Not Concentric ☐	☐	BOM/Route ☐	☐
Equip/Tooling ☐	☐	Supplier ☐	☐	Cracks ☐	☐	Broken/Damage/Defect ☐	☐
Handling/Pre ☐	☐	Training ☐	☐	Crimp/Kink/Ripple/Wave ☐	☐	Inspection Incomplete/Unqualified ☐	☐
Material ☐	☐	Use for Testing ☐	☐	Cuffs ☐	☐	Contamination ☐	☐
Internal Transport ☐	☐	Poor Information ☐	☐	Crushing ☐	☐	Countersink ☐	☐
Tribal Knowledge ☐	☐	Rushing ☐	☐	Heat Treat ☐	☐	Cut Too Short ☐	☐
LOA ☐	☐	Product Improvement ☐	☐	Wave/Twist in Tube ☐	☐	Instructions Incomplete/Unclear ☐	☐
Substation ☐	☐	Process Improvement ☐	☐	Marks/Chatter ☐	☐	Drill Holes ☐	☐
Past Expiry Date ☐	☐	Manufacturing Process ☐	☐	OTHER : _____ _____ _____			
Misidentified ☐	☐	Past Due ☐	☐				

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Monday, September 12, 2016 9:01:35 AM

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Page 3

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N900040100

Setup Start

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Item Name: Wearpad

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Weld per dwg & QSI004 4.5	0.00							
150 autoweld 1	Memo	0.00				4	0	16-16-11	
Automated Welding 1	Weld hardcoat as per dwg A/R 8259 Batch: <u>14135051</u>								
160	QC5- Inspect part completeness to step on W/O	0.00							
160 QC	Memo	0.01				4			
Quality Control									DAS 38 9-89 9104 1 130 OCT 4 1 2016
170	QC10- Inspect visual per QSI004- ground welds	0.00							
170 QC	Memo	0.00				4			
Quality Control									DAS 38 9-89 9104 1 130 OCT 11 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
193		0.00							DAS 41 9-89
193						4			
HandFinish	Memo	0.00							
Hand Finishing	APPLY TEXTURE COATING ON TOP CONCAVE SURFACE AS PER DWG								16-10-12
	TEXTURE COATING BATCH: <u>135621</u>								
196	QC3- Inspect Part Finish	0.00							DAS 38 9-89
196						(4)			
QC	Memo	0.01							OCT 14 2016
Quality Control									
200	Identify as per dwg & Stock Location: _____	0.00							
200						4			DAS 6 9-89
Packaging	Memo	0.01							OCT 17 2016
Packaging	LOCATION ; FP001								

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Work Order ID 151008

Monday, September 12, 2016 9:01:35 AM

151008

Page 5

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N900040100Setup Start ***NS1***

Revision ID:

Item Name: Wearpad

Stop ***NS2***

Start Date: 9/14/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/19/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00

210DAS
21
9-89

OCT 1 R 2016

QC

Memo

0.07

Quality Control

DAS
21
9-89

OCT 17 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : _____					

Picklist Print

Monday, September 12, 2016 9:01:34 AM

Work Order ID: 151008

151008

Parent Item: D3847-11

D3847-11

Parent Item Name: Wearpad

Start Date: 9/14/2016

Required Date: 9/19/2016

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP RevA: New issue DD verified by:EC

IPP REV:B

16.03.31 AS PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

sf

92.6000

0.712842

M304S16GA

PR 16/09/23

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT010

92.6

m135377

52.6

m135559

40

0.7

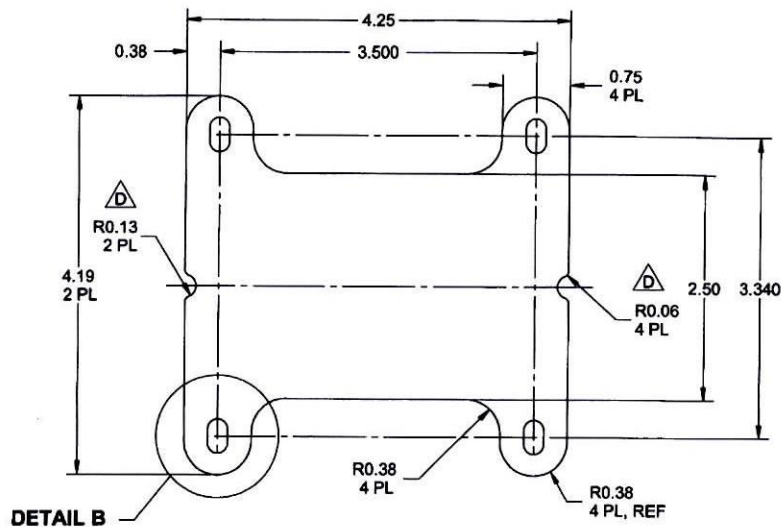
DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

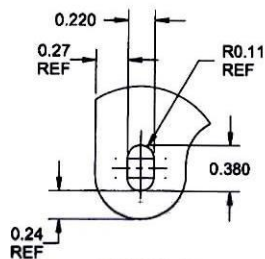
QA Closed: _____ Date: _____

Work Order update only ☐

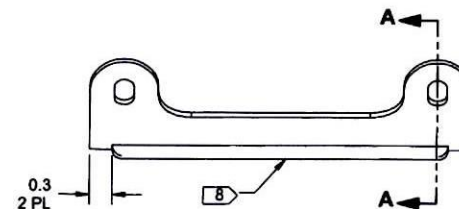
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : _____					



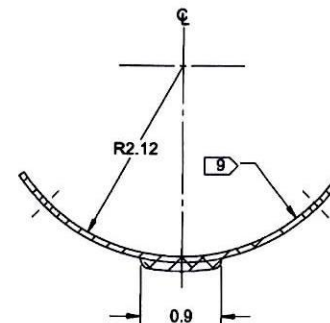
D3847-1F WEARPAD
(FLAT PATTERN)



DETAIL B
4 PL
SCALE 2X



D3847-1 WEARPAD
(MAKE FROM D3847-1F)



SECTION A-A

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151008 MJS
1609-13

D	UPDATE NOTES FOR AUTOMATED WELDING. UPDATE CURRENT DRAWING STANDARDS AND TOLERANCES. REMOVE FINISH. ADD TEXTURED COATING NOTE. UPDATE MATERIAL NOTES. -3F, -5F, -7F & -9F SIDE VIEW REMOVED. 3B7, 7B2, 7B1 REMOVED 0.080 DIMENSION. D81, D81, 8C7, 8C5, R0.13 TOOLING NOTCHES ADDED ACCORDINGLY 8C2. 0.2 DIM WAS 0.05 (MANUFACTURING REQUEST).	AJS	15.09.28
C	REMOVED D3848-3I-5I-7I-9 GASKETS, ZN D2-1. ADDED TEXTURED COATING, ZN B3-1. UPDATED WEIGHTS, ZN C3-1/A8-2	AK	14.08.06
B	CORRECT TYPO D3847-047 WAS D3847-045. ZN B5-1; 5.82 WAS 6.25 (ZN A4-2); 45.28 WAS 45.71 (ZN B4-5)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	AJS		
CHECKED	ML		
MFG. APPR.	DD		
APPROVED	WM		
DE APPR.	DS		
DATE	15.09.28		

DART AEROSPACE USA, INC.
EUGENE, OR

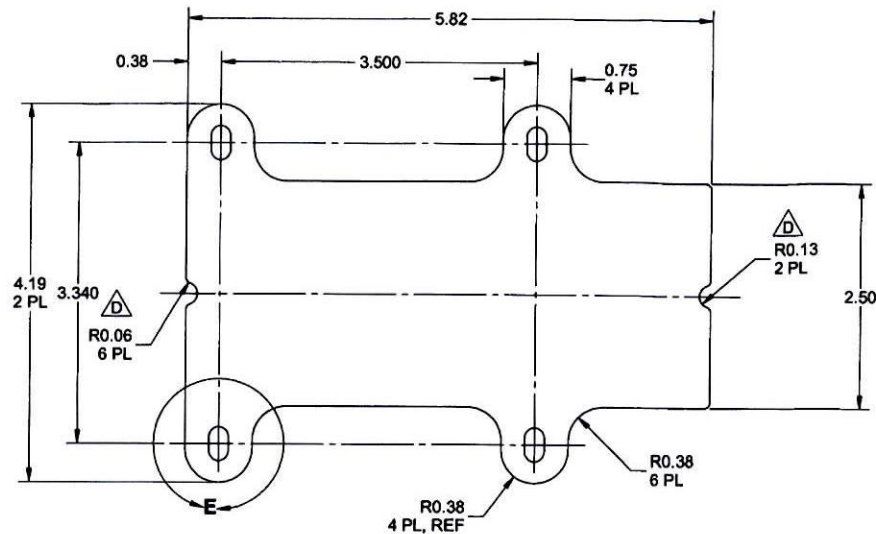
DRAWING NO. **D3847** REV. D
SHEET 1 OF 7
TITLE **WEARPLATE ASSY** SCALE NTS

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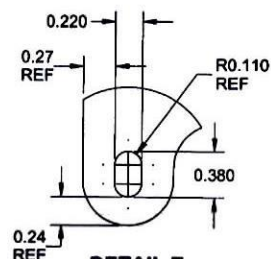
- NOTES:**
- 1) MATERIAL -1F: AISI 304/316 STAINLESS STEEL 16 GAUGE 0.063 THICK PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 REF DART SPEC. M304S16GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.23 lbs
 - 8) BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
 - 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.02-0.04 THICK, PER DART QSI 005 4.9

RELEASED
2016-03-31
EN 16-554

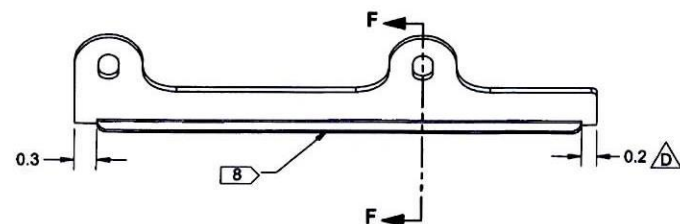
APPROVED



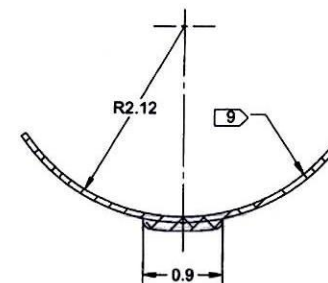
D3847-11F WEARPAD
(FLAT PATTERN)



DETAIL E
4 PL
SCALE 2X



D3847-11 WEARPAD
(MAKE FROM D3847-11F)



SECTION F-F

NOTES:

- 1) MATERIAL -11F: AISI 304/316 STAINLESS STEEL 16 GAUGE 0.063 THICK
PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES-UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.43 lbs
- 8) BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.02-0.04 THICK, PER DART QSI 005 4.9

RELEASED
2016-03-31

APPROVED

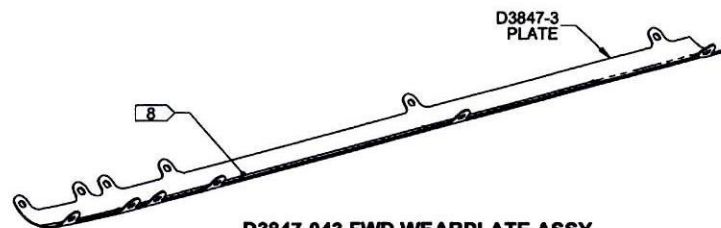
DESIGN	RF
DRAWN	AJS
CHECKED	ML
MFG. APPR.	DD
APPROVED	WM
DE APPR.	DS
DATE	15.09.28

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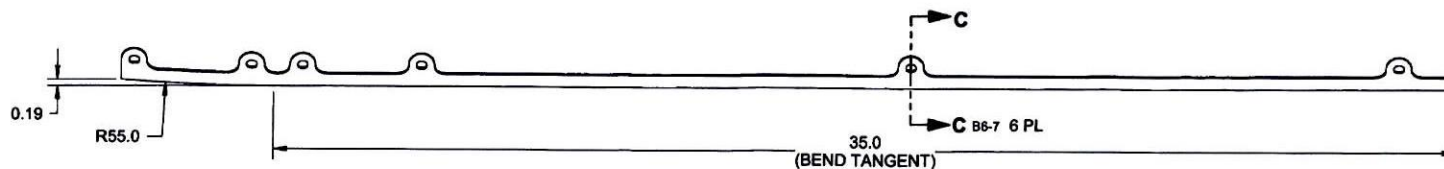
DRAWING NO. **D3847** REV. D
SHEET 2 OF 7
TITLE **WEARPLATE ASSY** SCALE NTS

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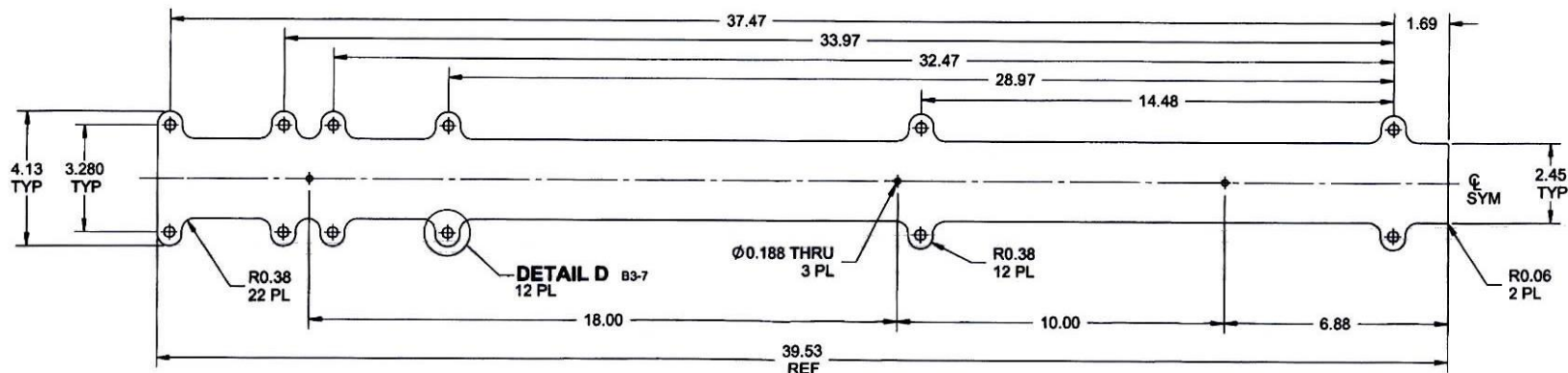
ITEM	QTY	P/N	DESCRIPTION
	X	D3847-043	FWD WEARPLATE ASSY
1	1	D3847-3	PLATE



D3847-043 FWD WEARPLATE ASSY



D3847-3 PLATE
(MAKE FROM D3847-3F)



D3847-3F PLATE
(FLAT PATTERN)

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 18 GAUGE 0.050 THICK
PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 1.48 lbs
 - 8) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.02-0.04 THICK, PER DART QSI 005 4.9

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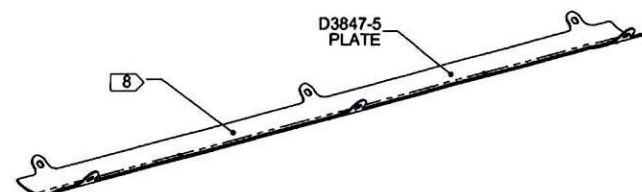
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APPROVED	WM
DE APPR.	DS
DATE	15.09.28

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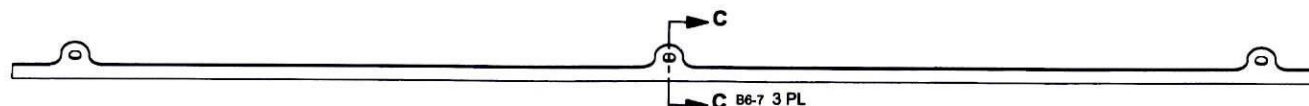
DRAWING NO.	REV. D
D3847	SHEET 3 OF 7
TITLE	SCALE
WEARPLATE ASSY	NTS

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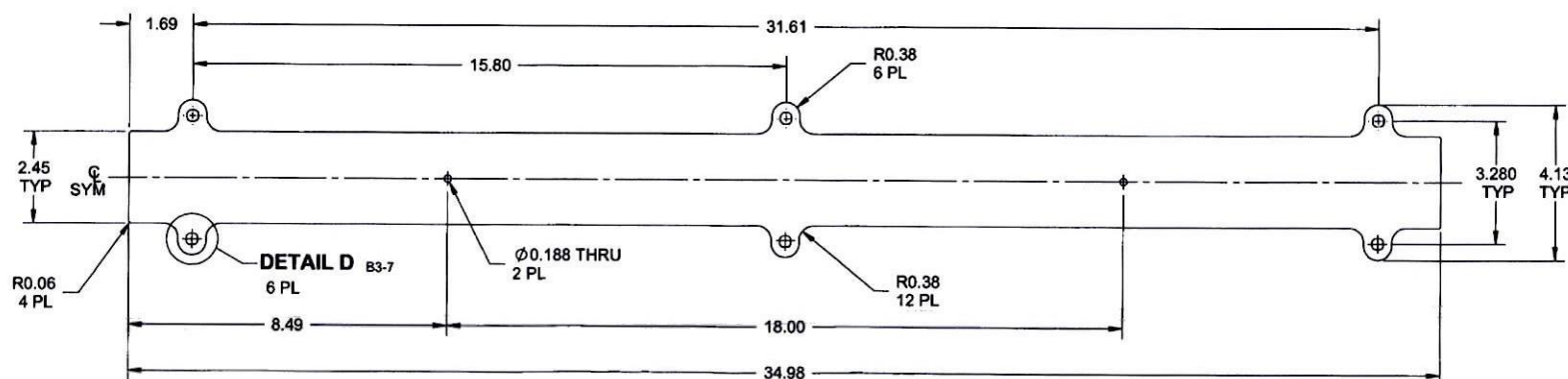
ITEM	QTY	P/N	DESCRIPTION
	X	D3847-045	AFT WEARPLATE ASSY
1	1	D3847-5	PLATE



D3847-045 AFT WEARPLATE ASSY



D3847-5 PLATE
(MAKE FROM D3847-5F)



D3847-5F PLATE
(FLAT PATTERN)

NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL 18 GAUGE 0.050 THICK
PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S18GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1

7) WEIGHT: 1.29 lbs

8) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.02-0.04 THICK, PER DART QSI 005 4.9

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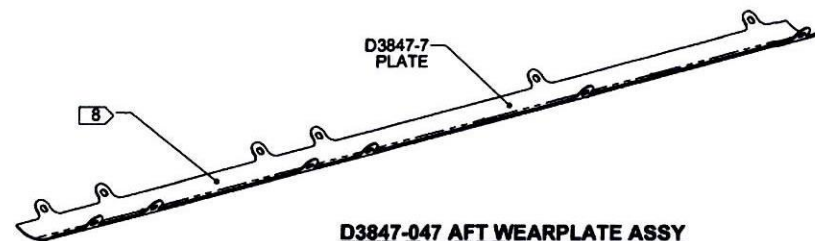
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APPROVED	WM
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DATE	15.09.28

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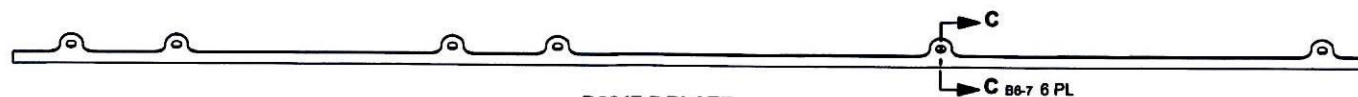
DRAWING NO.	REV. D
D3847	SHEET 4 OF 7
TITLE	SCALE
WEARPLATE ASSY	NTS

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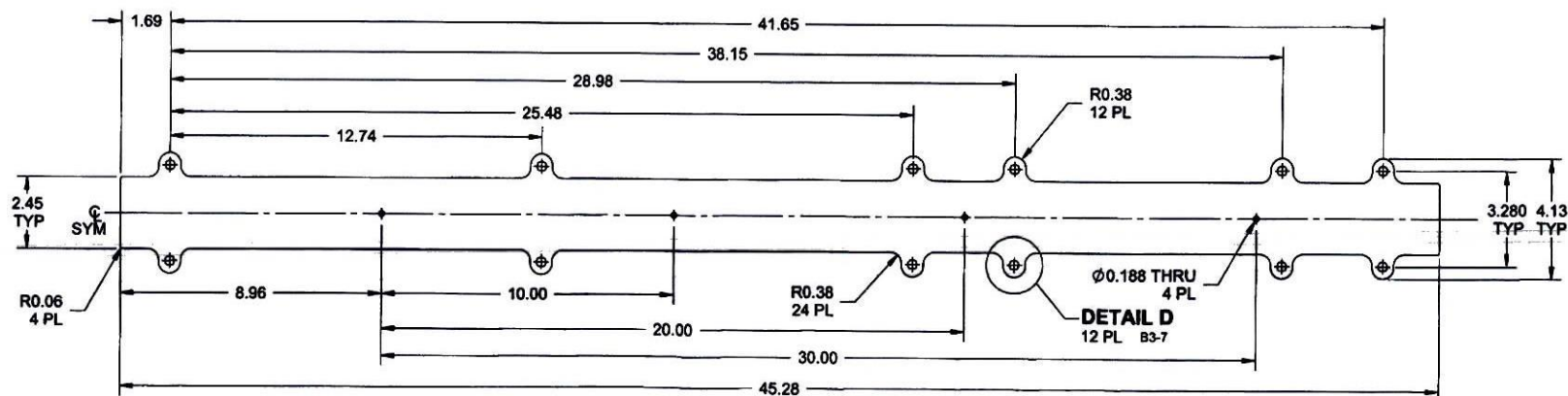
ITEM	QTY	P/N	DESCRIPTION
	X	D3847-047	AFT WEARPLATE ASSY
1	1	D3847-7	PLATE



D3847-047 AFT WEARPLATE ASSY



D3847-7 PLATE
(MAKE FROM D3847-7F)



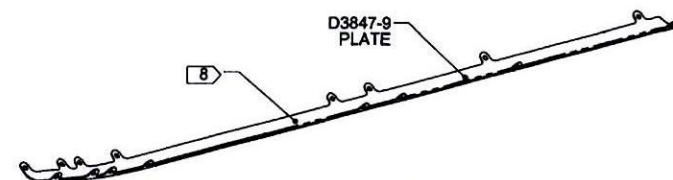
D3847-7F PLATE
(FLAT PATTERN)

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 18 GAUGE 0.050 THICK
PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 1.70 lbs
 - 8) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.02-0.04 THICK, PER DART QSI 005 4.9

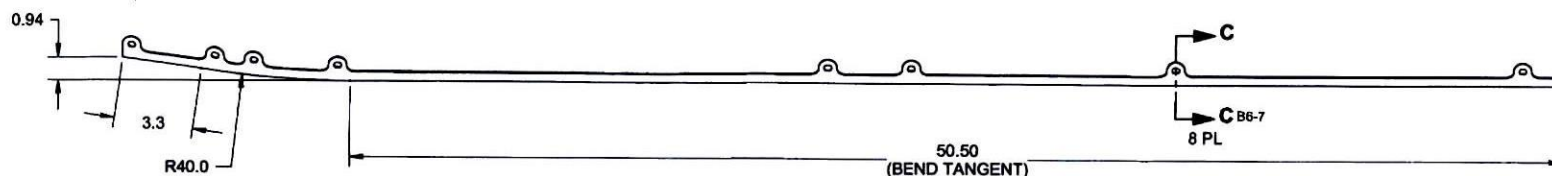
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DESIGN	RF	DART AEROSPACE USA, INC.	
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CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	DD	D3847	SHEET 5 OF 7
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
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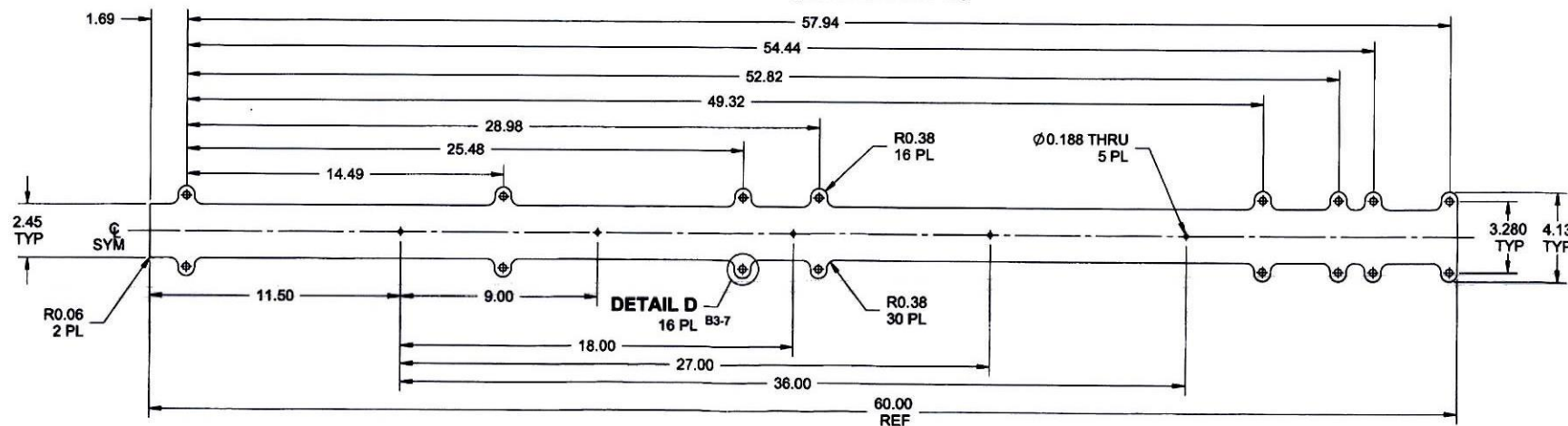
ITEM	QTY	P/N	DESCRIPTION
	X	D3847-049	WEARPLATE ASSY
1	1	D3847-9	WEARPLATE



D3847-049 AFT WEARPLATE ASSY



D3847-9 PLATE
(MAKE FROM D3847-9F)



D3847-9F PLATE
(FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 18 GAUGE 0.050 THICK
PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.86 lbs
- 8) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.02-0.04 THICK, PER DART QSI 005 4.9

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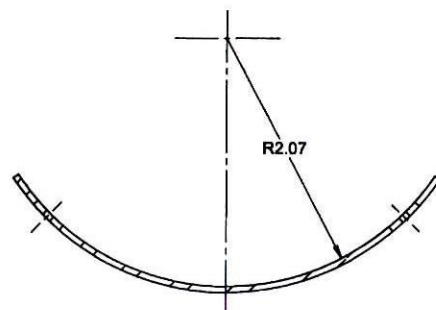
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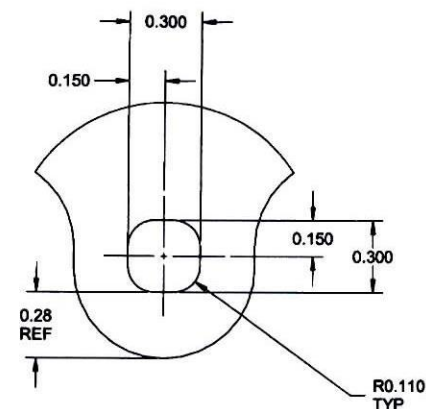
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D3847	SHEET 6 OF 7
TITLE	SCALE
WEARPLATE ASSY	NTS

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SECTION C-C
SCALE 4X
C3-2
C4-3
C3-4
C2-5



DETAIL D
SCALE 4X
B5-2
B6-3
B3-4
B4-5

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APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
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